

Work Order ID 92819

November-09-12 1:34:37 PM

92819

Page 1

Item ID: D3953-19

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gas Spring Bracket

Start Date: 11/09/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-11-09 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	C								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3953								
304.125	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

16 0 Jm 12-11-12

16 0 Jm 12-11-12

Work Order ID 92819

92819

Page 2

November-09-12 1:34:37 PM

Item ID: D3953-19

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gas Spring Bracket

Start Date: 11/09/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 12.11.15				16			
130 *130* Small Fab Small Fab	Memo 1- CHAMFER HOLE AS PER DWG 2- DEBURR IF NECESSARY	0.00 0.00				16x			12/11/16
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 12.11.19				16			

Work Order ID 92819***92819***

Page 3

November-09-12 1:34:37 PM

Item ID: D3953-19

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gas Spring Bracket

Start Date: 11/09/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>077</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ME
12-11-19

Picklist Print

November-09-12 1:34:36 PM

Page 1

Work Order ID: 92819

Parent Item: D3953-19

Parent Item Name: Gas Spring Bracket

Start Date: 11/09/12

Required Date: 11/28/12

Start Qty: 16.00

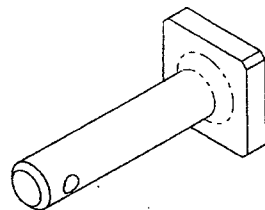
Required Qty: 16.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revC DD 10.03.02
verified by:EC

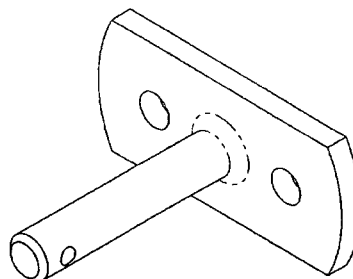
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	151.2500	0.018	0.3031584 0.4			Jm 12-11-12
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		151.25							
				122521		151.25		122521					



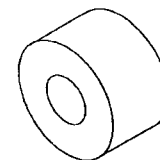
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



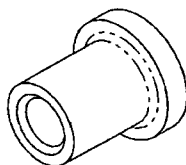
D3953-5 GAS SPRING STUD, BASE



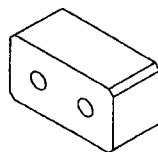
D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



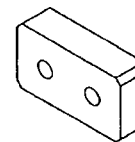
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



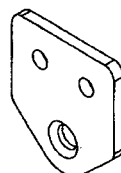
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

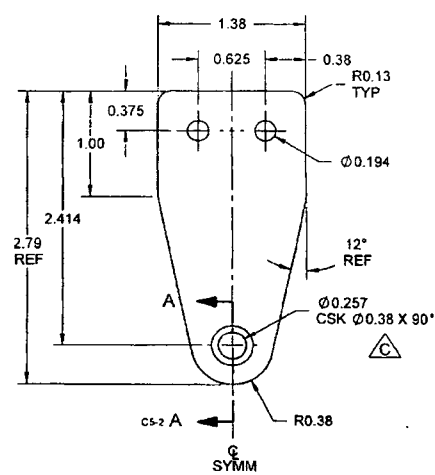
RELEASED
R 2010-02-26

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 92819 MLC
12-11-09

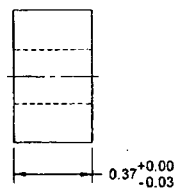
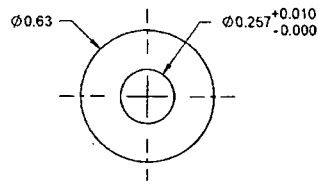


D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

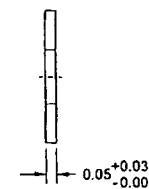
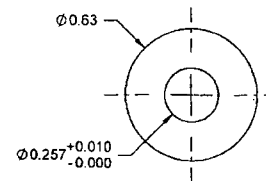
C	PARTS -19 & -21 ADDED (SHT 16.4). CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4). C SYMM WAS C SYM ABOUT (C7-2, C7-4). SECTION C-C REPOSITIONED TO B2.4 REASON: ADDL PARTS REQ, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13. MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	W		
MFG. APPR.	W		
APPROVED	W		
DE APPR.	W		
DATE	10.01.29		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS REV. C SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



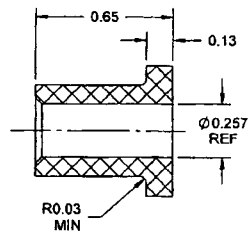
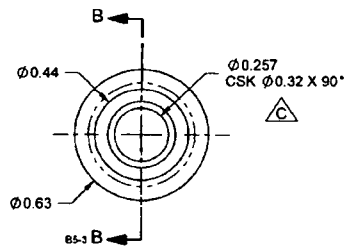
92819



D3953-7 GAS SPRING SPACER

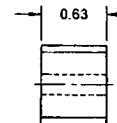
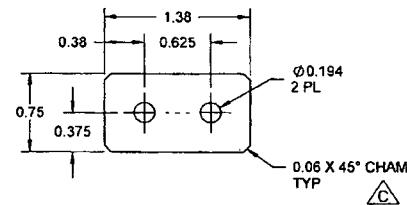


D3953-9 GAS SPRING WASHER



SECTION B-B B7-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

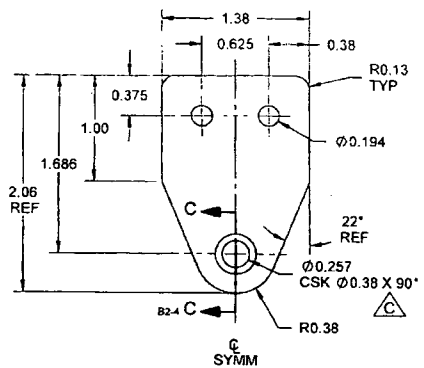
-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

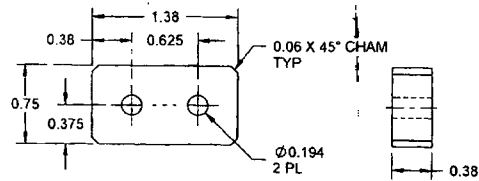
RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF COMMERCE OR INDUSTRY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

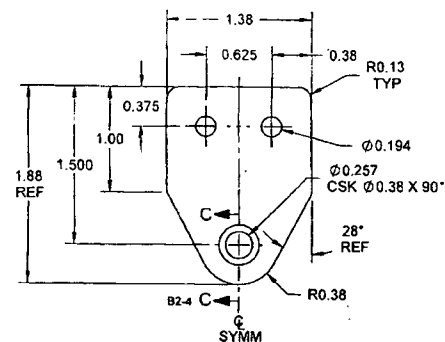
92819



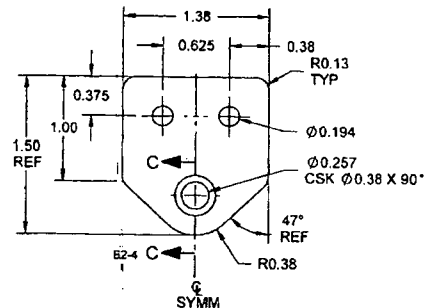
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



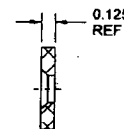
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO. D3953	REV. C
MFG. APPR.	[Signature]	TITLE	SHEET 4 OF 4
APPROVED	[Signature]	GAS SPRING LID COMPONENTS	SCALE
DE APPR.	[Signature]		NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND IS APPROVED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 12/7/26

Batch No: M12251

Supplier: THYSSSEN

Dart P/O: 17463

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒ N/A ☐
Shipment Complete: DAS Yes ☐ No ☒ N/A ☐
QC6 Inspection: 14 12/07/27 Yes ☐ No ☒ N/A ☐
Work Order: 0-85 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M304B0.5W 0000		24	0	0	24	
M244B 0625X300		12	0	0	12	
M6061T65032		96	0	0	96	
M7075T33250063		256	0	0	6	

Initials of receiver (if shipment OK) Level 12 CE

Production/Admin: 12/1/26
Date
Received/Costing
Initial

Location _____

Purchase Order Receipt Listing

Thursday, July 26, 2012 8:56:04 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO17463 Receipt Dates from 7/26/2012 to 7/26/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VC-COP001 Thyssenkrupp Materials CA Ltd											
VendorID/Vendor Name											
PO17463	3		M303BI.000X1.000 f		7/25/2012	7/26/2012	12.7000	\$13.49	0.0000	0	\$171.36
CAD	No		303 BAR 1" X 1" f		12.0000	DESJ02		\$171.36	0.0000	0	
			122521								
	6		M304S11GA sf		7/23/2012	7/26/2012	280.0000	\$8.85	0.0000	0	\$2,478.17
	No		304/316 0.125 Sheet sf		280.0000	DESJ02		\$2,478.17	0.0000	0	
			122521								
	7		M6061T6B0.500X01. f		7/23/2012	7/26/2012	24.0000	\$1.55	0.0000	0	\$37.09
			250								
	No		6061-T6 Bar .500 x f		24.0000	DESJ02		\$37.09	0.0000	0	
			1.25								
			122521								
	8		M6061T6B0.500X06. f		7/23/2012	7/26/2012	24.0000	\$7.03	0.0000	0	\$168.78
			000								
	No		6061-T6 Bar .500 x f		24.0000	DESJ02		\$168.78	0.0000	0	
			6.00								
			122521								
	9		M6061T6B0.750X01. f		7/23/2012	7/26/2012	24.0000	\$2.62	0.0000	0	\$62.80
			500								
	No		6061-T6 Bar .750 X f		24.0000	DESJ02		\$62.80	0.0000	0	
			1.50								
			122521								
	10		M6061T6B1.000X04. f		7/23/2012	7/26/2012	24.0000	\$9.24	0.0000	0	\$221.77
			000								
	No		6061-T6 Bar 1.00 x f		24.0000	DESJ02		\$221.77	0.0000	0	
			4.00								
			122521								
	11		M6061T6B1.250X01. f		7/23/2012	7/26/2012	12.0000	\$3.60	0.0000	0	\$43.18
			250								
	No		6061-T6 Bar 1.25 x f		12.0000	DESJ02		\$43.18	0.0000	0	
			1.25								
			122521								

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-COP001	Thyssenkrupp Materials CA Ltd								
PO17463	12		M6061T6B1.500X02. f 000		7/23/2012	7/26/2012	12.0000	\$6.87	0.0000	0	\$82.43
CAD	No		6061-T6 Bar 1.50 x f 2.00 122521		12.0000	DESJ02		\$82.43	0.0000	0	
	13		M6061T6B2.000X02. f 250		7/23/2012	7/26/2012	12.0000	\$11.61	0.0000	0	\$139.34
	No		6061-T6 Bar 2.00 x f 2.25 122521		12.0000	DESJ02		\$139.34	0.0000	0	
	14		M6061T6R1.000 f		7/23/2012	7/26/2012	24.0000	\$1.80	0.0000	0	\$43.18
	No		ROUND BAR 1.00" f 122521		24.0000	DESJ02		\$43.18	0.0000	0	
	15		M6061T6R3.500 f		7/23/2012	7/26/2012	12.0000	\$23.06	0.0000	0	\$276.73
	No		6061 RD bar 3.50 f 122521		12.0000	DESJ02		\$276.73	0.0000	0	
	17		M6061T6S.080 sf		7/23/2012	7/26/2012	96.0000	\$3.05	0.0000	0	\$292.43
	No		6061-T6 .080 Sheet sf 122521		96.0000	DESJ02		\$292.43	0.0000	0	
	18		M6061T6S.125 sf		7/23/2012	7/26/2012	64.0000	\$4.75	0.0000	0	\$304.20
	No		6061-T6 .125 Sheet sf 122521		64.0000	DESJ02		\$304.20	0.0000	0	
Total Received Quantity:											620.7000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$4,321.47
Total Balance Due Quantity:											0.0000

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

No: PEC 777693
Ship Date 23Jul12 at 10:57 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

B I L L O F L A D I N G

1) Our Order PEC-472083- 1 Your PO # 17463
STAINLESS STEEL SQ BAR 303 STAINLESS
1.00" X 151.0000"

Heat Number
245298

Tag No
88401

Quantity
12 ' 7.0000 "

PCS
1

MTR

Wt LBS
43

2) Our Order PEC-472083- 2 Your PO # 17463
STAINLESS STEEL SHEET 304-2B
.1200 Nom X 48.0000" X 120.0000"

Heat Number
SF29688

Tag No
88728

Quantity
280.00 SFT

PCS
7

MTR

Wt LBS
1347

3) Our Order PEC-472083- 3 Your PO # 17463
ALUMINUM FLAT BAR 6061-T6511
.50" x 1.250" X 144.0000"

Heat Number
Z00248009

Tag No
88402

Quantity
24 FT

PCS
2

MTR

Wt LBS
17

4) Our Order PEC-472083- 4 Your PO # 17463
ALUMINUM FLAT BAR 6061-T6511
.50" X 6.00" X 144.0000"

Heat Number
201210006

Tag No
88403

Quantity
24 FT

PCS
2

MTR

Wt LBS
84

5) Our Order PEC-472083- 5 Your PO # 17463
ALUMINUM FLAT BAR 6061-T6511
.750" X 1.50" X 144.0000"

Heat Number
HK079 712

Tag No
88404

Quantity
24 FT

PCS
2

MTR

Wt LBS
32

Page: 1Continued

2 10/2/26

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

25 JUL 2012

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

SHIP FROM:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (- 1)
DART AEROSPACE

B I L L O F L A D I N G
No: PEC 777693
Ship Date 23Jul12 at 10:57 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

B I L L O F L A D I N G

6) Our Order PEC-472083- 6 Your PO # 17463

ALUMINUM FLAT BAR 6061-T6511

1.00" x 4.00" X 144.0000"

Heat Number
201210303

Tag No
88405

Quantity PCS MTR Wt LBS
24 FT 2 114

7) Our Order PEC-472083- 7 Your PO # 17463

ALUMINUM SQUARE BAR 6061-T6511

1.250" X 144.0000"

Heat Number
Z00240017

Tag No
88406

Quantity PCS MTR Wt LBS
12 FT 1 23

8) Our Order PEC-472083- 8 Your PO # 17463

ALUMINUM FLAT BAR 6061-T6511

1.50" x 2.00" X 144.0000"

Heat Number
201209117

Tag No
88407

Quantity PCS MTR Wt LBS
12 FT 1 43

9) Our Order PEC-472083- 9 Your PO # 17463

Part # - OFFERING*****

Rel # -

ALUMINUM FLAT BAR 6061-T6511

2.00" x 2.50" X 144.0000"

Heat Number
C7331164

Tag No
88408

Quantity PCS MTR Wt LBS
12 FT 1 71

10) Our Order PEC-472083- 10 Your PO # 17463

ALUMINUM ROUND BAR 6061-T6511

1.00" DIA X 144.0000"

Heat Number
Z00216020

Tag No
88409

Quantity PCS MTR Wt LBS
24 FT 2 23

11) Our Order PEC-472083- 11 Your PO # 17463

ALUMINUM ROUND BAR 6061-T6511

3.50" DIA X 144.0000"

MTR

Page: 2Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

25 JUL. 2012

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

SHIP FROM:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

SHIP TO: (1)
DART AEROSPACE

NO: PEC 777693
SHIP DATE 23Jul12 at 10:57 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

B I L L O F L A D I N G
Heat Number Tag No Quantity PCS Wt LBS
21112151 88410 12 FT 1 140

12) Our Order PEC-472083- 12 Your PO # 17463

ALUMINUM SHEET 6061 T6

.0810 Nom X 48.0000" X 144.0000"

Heat Number Tag No
25872/01/00 88035

Quantity PCS
96.00 SFT 2

MTR Wt LBS
105

13) Our Order PEC-472083- 13 Your PO # 17463

ALUMINUM SHEET 6061 T6

.1250 Nom X 48.0000" X 96.0000"

Heat Number Tag No
30286/01/00 88036

Quantity PCS
64.00 SFT -2

MTR Wt LBS
109

14) Our Order PEC-472083- 14 Your PO # 17463

Part # PLATE ASTM B 209 QQ-A-250/12 Rel #

ALUMINUM PLATE 7075T7351

2.50" THICK X 3.2500" X 72.0000"

*** BACK ORDER ***

TOTAL: Tags 13 PCS 26 Wt LBS 2151

Heat Number
201209117
201210006
201210303
21112151
245298
25872/01/00
30286/01/00
HK079 712
SF29688
Z00216020

*** Chemical Analysis ***

Page: 3Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

25 JUL 2012

DATE

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship To: (1)
DART AEROSPACE

No: PEC 777693
Ship Date 23Jul12 at 10:57 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

=====

B I L L O F L A D I N G

Z00240017
Z00248009

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

TOTAL 1 BDL, 2 SKIDS GW. 2477 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***

**** TEL. 800-926-2600 ****

* WE STOCK STAINLESS STEEL *

* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 4 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

25 JUL 2012

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

STAINLESS STEEL SHEET 304-2B
1200 Nom X 48.0000" X 120.0000"
PART NO.

PO/Rel 17463

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-777693-002

23Jul12
Pg 1/1

Signed by: _____

DAS
14
8-89

12/07/27

产品质量证明书 MILL TEST CERTIFICATE



江苏大明金属制品有限公司

JANGSU DAMING METAL PRODUCTS CO., LTD.

地址: 无锡市太湖新城
ADDRESS: NO.1514, TONGJIANG ROAD
WUXI, JIANGSU PROVINCE, CHINA
TEL: 81095888

订单号: 020008
客户名称: GLOBAL STAINLESS STEEL INC.
订单号: _____
收货厂家: _____
收货地址: _____

品名: COLD ROLLED STAINLESS
Commodity: STEEL SHEET, BLT EDGE

编号: M120302001
Invoice No.: _____
发行日期: 2012-4-15
Date: _____

序号 No.	Product No.	牌号 Type	表面加工 Surface Finish	产品尺寸 Product Size			重量 NET Weight KG	标准 Specification	拉伸试验 Tensile Test			硬度 Hardness HV0.05	钢号 STEEL NO.	炉号 HEAT NO.	化学成分 Chemical Composition (%)							
				厚度 Thickness MM	宽度 Width MM	长度 Length MM			屈服强度 R _e L2 Mpa	抗拉强度 R _m Mpa	延伸率 A %				C	Si	Mn	P	S	Ni	Cr	N
1	P001693080	304	2B	0.5	1219	2438	910.04	ASTM A240	275	731	65	167	QW40130C	SF28811	0.0510	0.5040	1.0820	0.0321	0.0057	8.02	18.26	/
2	P001693081	304	2B	0.5	1219	3048	906.06	ASTM A240	275	731	65	167	QW40130C	SF28811	0.0510	0.5060	1.0820	0.0321	0.0057	8.02	18.26	/
3	P001715073	304	2B	0.5	1219	3048	930.00	ASTM A240	270	731	60	167	QW63401B	SF29408	0.0458	0.5120	1.0540	0.0208	0.0064	8.02	18.32	/
4	P001683219	304	2B	1.6	1219	2438	1818.74	ASTM A240	273	692	62	168	QW62078D	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
5	P001693220	304	2B	1.6	1219	3048	1831.49	ASTM A240	273	692	62	168	QW62078D	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
6	P001693221	304	2B	1.5	1219	3048	1761.74	ASTM A240	273	692	62	168	QW62078D	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
7	P001720553	304	2B	2.0	1219	3048	930.66	ASTM A240	293	706	58	173	QW20999A	SF28445	0.0428	0.4720	1.0360	0.0400	0.0051	8.06	18.17	/
8	P001694263	304	2B	3.0	1219	2438	1409.00	ASTM A240	281	663	61	175	QJ80403A	SF28888	0.0504	0.4510	1.1420	0.0343	0.0034	8.05	18.34	/
9	P001694265	304	2B	3.0	1219	3048	1407.64	ASTM A240	281	663	61	175	QJ80403A	SF28888	0.0504	0.4510	1.1420	0.0343	0.0034	8.05	18.34	/
10	P001705088	304	2B	2.0	1219	2438	1408.08	ASTM A240	287	714	55	174	QUC0023A	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
11	P001705121	304	2B	2.5	1219	3048	1393.94	ASTM A240	287	714	55	174	QUC0023A	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
12	P00169782	304	NO 4+	1.5	1219	2438	1800.45	ASTM A240	267	664	60	164	QW60101B	SF30027	0.0476	0.5270	1.0650	0.0306	0.0049	8.04	18.22	/
13	P00169789	304	NO 4+	1.5	1219	3048	1975.55	ASTM A240	267	664	60	164	QW60161B	SF30027	0.0476	0.5270	1.0650	0.0300	0.0040	8.04	18.22	/
14	P00169755	304	NO 4+	2.0	1219	2438	1903.80	ASTM A240	315	947	53	83	KA11234070A10	C3108695	0.0400	0.4500	1.0900	0.0300	0.0010	6.1	18.21	0.048
15	P001703038	304	NO 4+	2.5	1219	2438	1670.30	ASTM A240	287	714	55	174	QUC0023A	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/
16	P001703037	304	NO 4+	2.5	1219	2438	1670.30	ASTM A240	287	714	55	174	QUC0023A	SF30003	0.0378	0.4480	1.0270	0.0186	0.0022	8.05	18.17	/

尺寸 (Dimensions):
尺寸公差: 合格
Size and Surface: Guaranteed

底切所列产品均符合订单和标准的制造要求

WE HEREBY CERTIFY THAT THE MATERIAL HEREIN HAS BEEN MADE IN ACCORDANCE
WITH THE ORDER AND SPECIFICATION
此报告仅可完全复制

江苏大明金属制品有限公司
JIANGSU DAMING METAL PRODUCTS CO., LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17463**

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 1 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone 905 669 9444

Vendor Fax 905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
3	M303B1.000X1.000 <i>050</i>	303 BAR 1" X 1"	7/25/12 Yes	12.00 f <i>12.7</i>	Yours ppd	\$13.7500	\$165.00
Special Inst:			MATERIAL: AISI 303 SS BAR AS PER ASTM A582 NOTE: AISI 304/316 NOT ACCEPTABLE				
4	M304B0.500X2.500 <i>050</i>	304 BAR .500 x 2.50	7/25/12 Yes	24.00 f	Yours ppd	\$12.9083	\$309.80
Special Inst:			AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 (NOTE: AISI 303 NOT ACCEPTABLE)				
5	M304B0.625X3.000 <i>050</i>	304 BAR .625 X 3.00	7/25/12 Yes	12.00 f	Yours ppd	\$20.2500	\$243.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 2

Change Date: 7/17/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17463

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 2 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Special Inst: AISI 304/316 SS BAR OR AISI 304/316 SS
PLATE
AS PER ASTM A276 OR ASTM A240
(NOTE: AISI 303 NOT ACCEPTABLE)

6

M304S11GA

020

304/316 0.125 Sheet

7/23/12

Yes

280.00

sf

✓ Yours ppd

\$9.0193

\$2,525.40

1

Special Inst: MATERIAL: AISI 304/316 SS SHEET
ANNEALED 2B FINISH
AS MIL-S-5059 OR AMS 5513 (304) OR
AMS 5524 (316)
OR ASTM A240 OR ASME SA240

7

M6061T6B0.500X01.250

010

6061-T6 Bar .500 x 1.25

7/23/12

Yes

✓ 24.00

f

Yours ppd

\$1.5750

\$37.80

Special Inst: MATERIAL: 6061-
T6/T651/T6510/T6511/T62 ALUMINUM
BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

8

M6061T6B0.500X06.000

004

6061-T6 Bar .500 x 6.00

7/23/12

Yes

✓ 24.00

f

Yours ppd

\$7.1667

\$172.00

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required YES NO

Change Nbr:

2

Change Date:

7/17/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17463

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 3 of 6

Order From : VC-COP001
THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

9	M6061T6B0.750X01.500 003	6061-T6 Bar .750 X 1.50	7/23/12 Yes	✓ 24.00 f	Yours ppd 6/12/12/26	\$2.6667	\$64.00
---	-----------------------------	-------------------------	----------------	--------------	-------------------------	----------	---------

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

10	M6061T6B1.000X04.000 004	6061-T6 Bar 1.00 x 4.00	7/23/12 Yes	✓ 24.00 f	Yours ppd 6/12/12/26	\$9.4167	\$226.00
----	-----------------------------	-------------------------	----------------	--------------	-------------------------	----------	----------

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

11	M6061T6B1.250X01.250 003	6061-T6 Bar 1.25 x 1.25	7/23/12 Yes	✓ 12.00 f	Yours ppd 6/12/12/26	\$3.6667	\$44.00
----	-----------------------------	-------------------------	----------------	--------------	-------------------------	----------	---------

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required YES NO

Change Nbr: 2

Change Date: 7/17/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17463

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 4 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Special Inst:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

12 M6061T6B1.500X02.000

6061-T6 Bar 1.50 x 2.00

7/23/12

Yes

12.00

Yours ppd

\$7.0000

\$84.00

010

Special Inst:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

13 M6061T6B2.000X02.250

6061-T6 Bar 2.00 x 2.25

7/23/12

Yes

12.00

Yours ppd

\$11.8333

\$142.00

009

Special Inst:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

14 M6061T6R1.000

ROUND BAR 1.00"

7/23/12

Yes

24.00

Yours ppd

\$1.8333

\$44.00

d3

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required **YES** NO

Change Nbr: 2

Change Date: 7/17/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17463

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 5 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275, POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM
ROUND BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/
4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160
OR ASTM B211 OR ASTM B221

15	M6061T6R3.500 006	6061 RD bar 3.50	7/23/12 Yes	12.00 f	Yours ppd 12/17/26	\$23.5000	\$282.00
----	----------------------	------------------	----------------	------------	-----------------------	-----------	----------

Special Inst: MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM
ROUND BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/
4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160
OR ASTM B211 OR ASTM B221

16	M6061T6S.032 021	6061-T6 Sheet 0.032"	7/23/12 Yes	96.00 sf	Yours ppd	\$1.9792	\$190.00
----	---------------------	----------------------	----------------	-------------	-----------	----------	----------

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

17	M6061T6S.080 621	6061-T6 .080 Sheet	7/23/12 Yes	96.00 sf	Yours ppd 12/17/26	\$3.1042	\$298.00
----	---------------------	--------------------	----------------	-------------	-----------------------	----------	----------

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required- YES NO

Change Nbr: 2

Change Date: 7/17/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17463

Purchase Order Date 7/17/12

PO Print Date 7/17/12

Page Number 6 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275, POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

18

M6061T6S.125

6061-T6 .125 Sheet

7/23/12

Yes

64.00

Yours ppd

\$4.8438

\$310.00

Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

19

M7075T73B2.500X03.25

7075-T73 Bar 2.50 x 3.25

7/23/12

Yes

6.00

Yours ppd

\$49.6667

\$298.00

Special Inst:

7075-T73 (OR 7075-
T7351/T73510/T73511) BAR PER ASM-
QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS
4124) OR AMS-QQ-A-250/12 (AMS 4078)

PO Total:

\$5,435.00

Change Nbr:

2

Change Date:

7/17/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO